

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
D3339	Rev B								
*100*	FLOW WATER JET	0.00							DAS 23 9-89
Waterjet	Memo	0.00				15	0		
FLOW CNC Waterjet	1-Cut as per Dwg D3339								
1010 .063"	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2-Deburr if necessary								
QC	QC2- Inspect parts off machine FAI/FAIB	0.00							DAS 23 9-89
Quality Control	Memo	0.00				15	0		
QC	QC8- Inspect parts - second check	0.00							DAS 38 9-89
Quality Control	Memo	0.00				15			

# Work Order ID 123959

September-04-14 10:21:35 AM

**\*123959\***

Page 2

Item ID: D3339-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad Centre  
 Start Date: 9/04/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 9/04/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	NC BRAKE	0.00		DAS 30 9-89		15			14/09/08
<b>*130*</b>									
Brake NC	Memo	0.00							
Brake NC	1-Deburr if necessary 2-Form as per Dwg D3339 using DT8326 and DT8261								
140	QC5- Inspect part completeness to step on W/O	0.00				15			DAS 38 9-89 14-9-9
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									
150	Large Fab	0.00				15			14-09-10
<b>*150*</b>									
Large Fab	Memo	0.00							
Large Fab	1-Weld Hard coat 7560 per Dwg D3339, use DT8210 & DT8810 Layout Jig A/R 7560 Hardcoat Batch: <u>m/29/84</u>								

# Work Order ID 123959

**\*123959\***

Page 3

Item ID: D3339-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Wearpad Centre  
 Start Date: 9/04/14 Start Qty: 10.00 **\*10\*** Cust Item ID:  
 Required Date: 9/04/14 Req'd Qty: 10.00 **\*10\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 <b>*160*</b> QC Quality Control	QC10- Inspect visual per QSI004- ground welds  Memo	0.00  0.00				15*	SEP 10 2014		DAS 24 9-89
170 <b>*170*</b> Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 11/28/564 Memo START TIME: 12:55 OVEN TEMPERATURE: 320 FINISH TIME: 1:25	0.00  0.00				15	11-9-10		DAS 34 9-89
180 <b>*180*</b> QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				15	14/09/11		

# Work Order ID 123959

\*123959\*

Page 4

September-04-14 10:21:35 AM

Item ID: D3339-3 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Wearpad Centre  
 Start Date: 9/04/14 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 9/04/14 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: <u>5T602</u>	0.00							
*190*									
Packaging	Memo	0.00				15x	DAS 28	SEP 11 2014	
Packaging							9-89		
200	QC21- Final Inspection - Work Order Release	0.00							
*200*									
QC	Memo	0.00							
Quality Control									

14/9/11 *[Signature]*  
 MLJ 14 09-11

# Picklist Print

September-04-14 10:21:35 AM

Page 1

Work Order ID: 123959

**\*123959\***

Parent Item: D3339-3

**\*D3339-3\***

Parent Item Name: Wearpad Centre

Start Date: 9/04/14

Required Date: 9/04/14

Start Qty: 10.00

Required Qty: 10.00

## Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M1010S16GA

Purchased

No

sf

196.3000

①

DAS

**\*M1010S16GA\***

**\*\***

**23**

9-89

14-09-5

1010/1025 sheet 16GA

### Location

### Loc Qty

### Loc Code

MAT019

196.3

124193

34

124254

0.3

124428

162

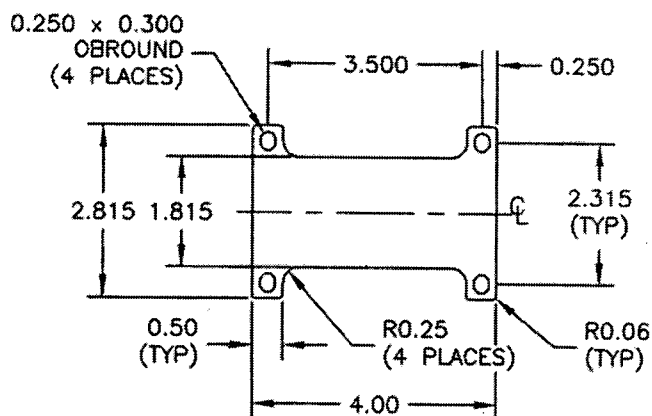
124428



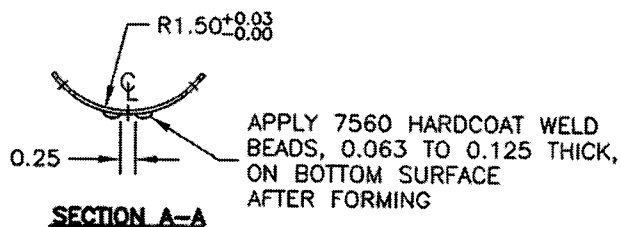


**RELEASED**  
05-11-27

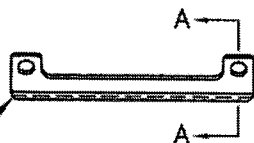
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3339	REV. B SHEET 1 OF 3
DATE 05.11.22		TITLE REPLACEMENT WEARPAD	SCALE 1:3
A	05.06.06	NEW ISSUE	
B	05.11.22	CORRECTED HOLE SPACING D3339-7F	



**D3339-1F FLAT PATTERN**

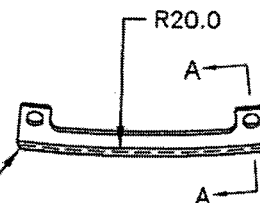


APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-3T1  
AFTER FORMING  
(SEE SECTION A-A)



**D3339-3 CENTER WEARPAD**  
(MADE FROM D3339-1F)

APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-5T1  
AFTER FORMING  
(SEE SECTION A-A)



**D3339-5 FORWARD WEARPAD**  
(MADE FROM D3339-1F)

**D3339-1F/-3/-5 WEARPAD**

**NOTES:**

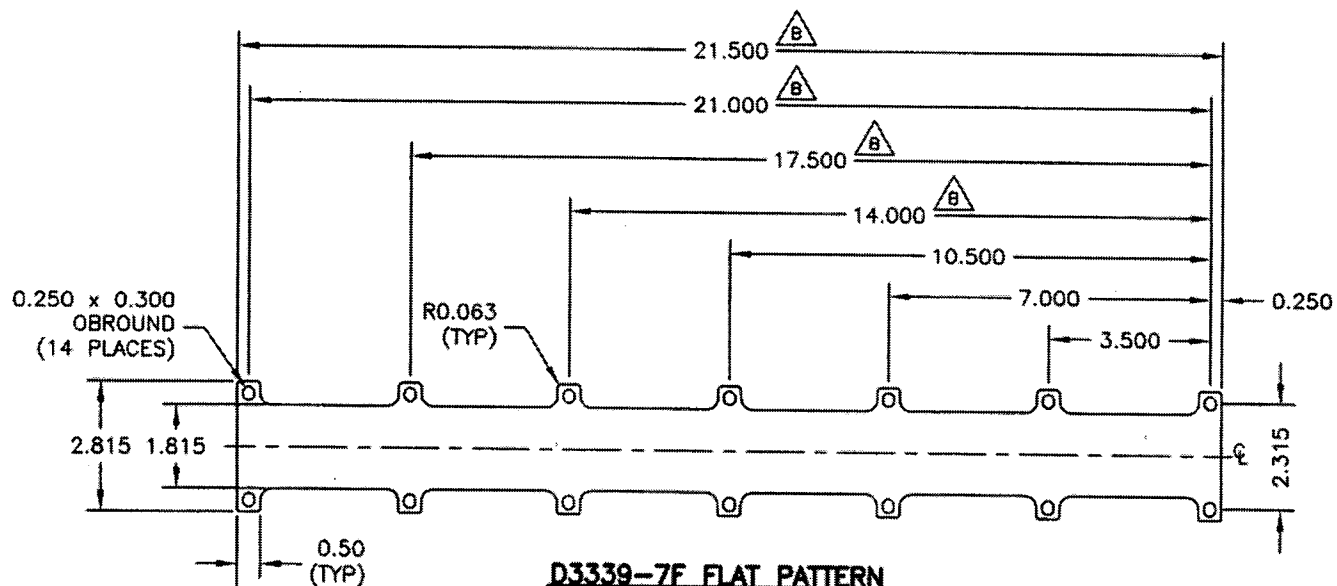
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

Copyright © 2005 by DART AEROSPACE LTD

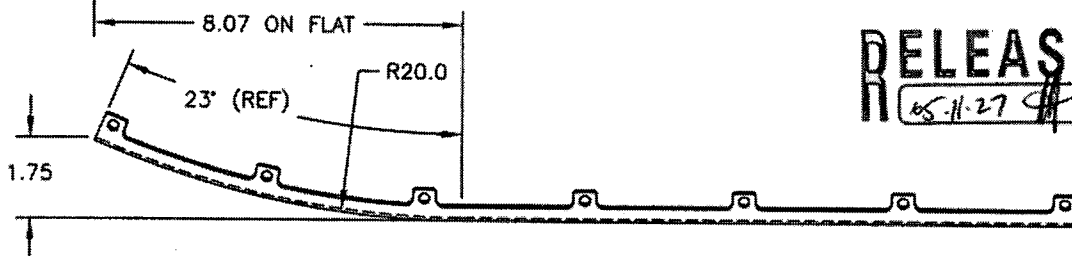
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



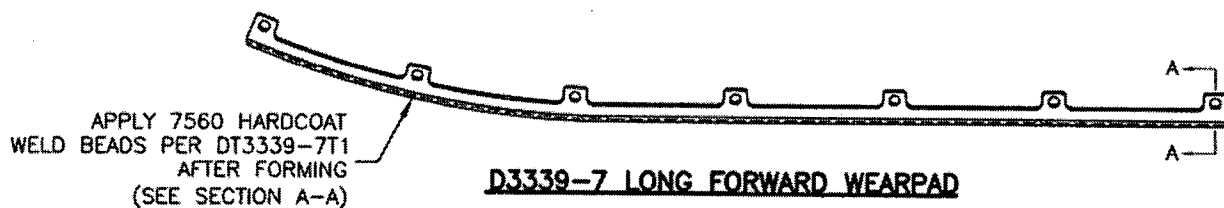
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3339	REV. B SHEET 2 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:4



**D3339-7F FLAT PATTERN**



**D3339-7B LONGITUDINAL BEND**



**D3339-7 LONG FORWARD WEARPAD**

**NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

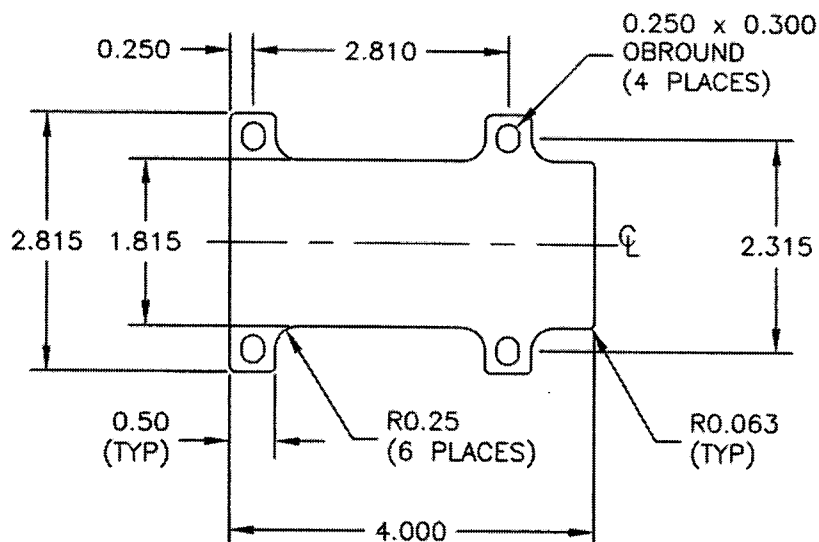
Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

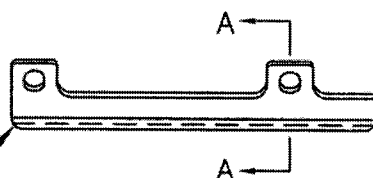


**DART**

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3339	REV. B SHEET 3 OF 3
DATE 05.11.22	TITLE REPLACEMENT WEARPAD		SCALE 1:2

**D3339-9F FLAT PATTERN****RELEASED**  
05.11.27 #

APPLY 7560  
HARDCOAT WELD BEADS  
PER DT3339-9T1  
AFTER FORMING  
(SEE SECTION A-A)

**D3339-9 AFT WEARPAD****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES COLD ROLLED STEEL 16 GAUGE (0.060 THICK)
- 2) PART IS SYMETRICAL ABOUT CENTER LINE
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF. 4.3.5.6) PER DART QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP CORNERS 0.063 MAX

**Copyright © 2005 by DART AEROSPACE LTD**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.